

# Work Order ID 84937

**\*84937\***

Page 1

May-29-12 1:11:17 PM

Item ID: D2917-1

Accept

**\*N900040100\***

Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Saddle LH

Start Date: 29/05/2012 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals: Process Plan: *MLJ*

Date: *12/05/30*

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D2917	Rev B								
100		0.00							
<b>*100*</b>	HAAS CNC VERTICAL MACHINING #1								
HAAS I		0.00							
HAAS CNC vertical machine #1	Memo Program batch number Machine Step No 1 as per Folio FA436 and visually inspect as per Dwg D2917 & attached Dimension Sheet Machine Step No 2 as per Folio FA436 and visually inspect as per Dwg D2917 & attached Dimension Sheet Machine Step No 3 as per Folio								
110		0.00							
<b>*110*</b>	CONVENTIONAL MILLING MACHINE								
Mill Conv		0.00							
Conventional Milling Machine	Memo Machine Keyway and inspect per Dwg D2917 & attached dimension sheet								
120		0.00							
<b>*120*</b>	QC2- Inspect parts off machine FAI/FAIB								
QC		0.00							
Quality Control	Memo								

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

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Page 2

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**\*N9000040100\***

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Revision ID:

Stop **\*NS2\***

Item Name: Saddle LH

Start Date: 29/05/2012 Start Qty: 20.00

**\*20\***

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 20.00

**\*20\***

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start **\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop **\*NR2\***

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

130

QC8- Inspect parts - second check

0.00

*Handwritten: 20 12.8.8*

**\*130\***

QC

Memo

0.00

*Handwritten: 20 4*

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

**\*140\***

HandFinish

Memo

0.00

*Handwritten: 20 12-6-11*

Hand Finishing

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*150\***

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

*Handwritten: 3200 F*

*Handwritten: 150 1730*

*Handwritten: 20 X 12/06/11*

*Handwritten: M121134*

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\*84937\*

Page 3

May-29-12 1:11:17 PM

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Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Saddle LH

Start Date: 29/05/2012 Start Qty: 20.00

\*20\*

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 20.00

\*20\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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160 QC3- Inspect Part Finish 0.00

\*160\*

QC Memo 0.00

Quality Control

20.00 *BLD-6-11*

170 Identify as per dwg & Stock Location: *424* 0.00

\*170\*

Packaging Memo 0.00

Packaging

*12/6/11 (20)*

180 QC21- Final Inspection - Work Order Release 0.00

\*180\*

QC Memo 0.00

Quality Control

*12/6/12*

*RD-06-12*

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# Picklist Print

May-29-12 1:11:22 PM

Page 1

Work Order ID: 84937

\*84937\*

Parent Item: D2917-1

\*D2917-1\*

Parent Item Name: Saddle LH

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 20.00

Required Qty: 20.00

## Comments:

IPP: A04.07.16New IssueKJ/JLM  
set B 07.08.07 ECN930 EC

verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6102-010		Manufactured	No			100	Each	63.0000	1	20			

\*D6102-010\*

Saddle Billet

\*\*

B.n 12/06/03

## Location

## Loc Qty

## Loc Code

MAT043

3

51423

1

53519

2

MAT046

60

→ 75833

60

20.0

**Dart Aerospace Ltd**

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**Dart Aerospace Ltd**

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# Dart Aerospace Ltd

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# Dart Aerospace Ltd

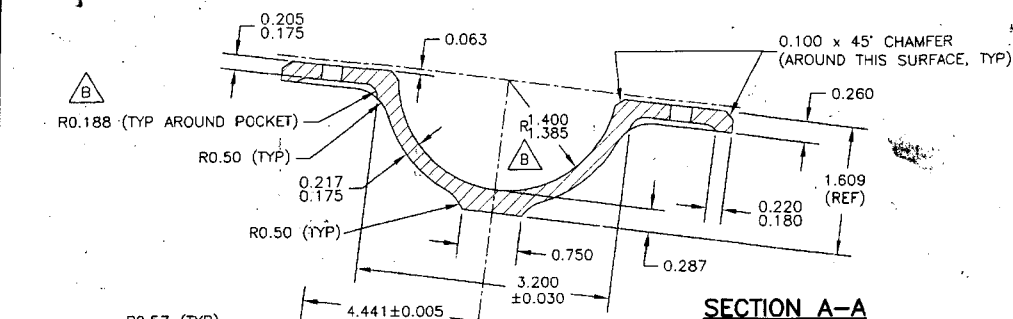
W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

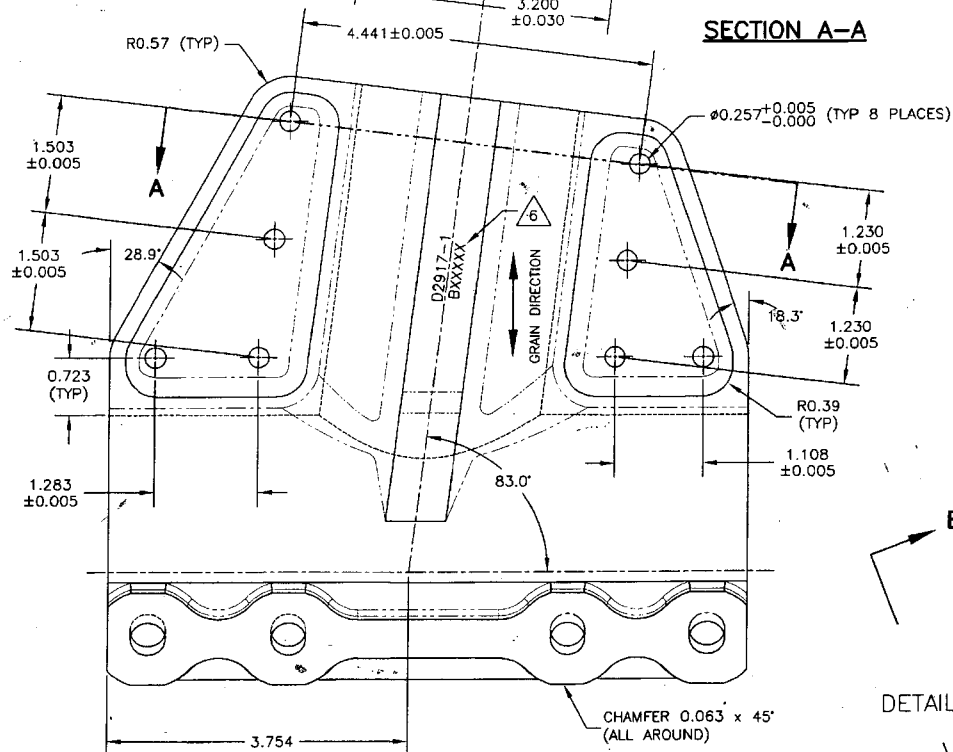
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SECTION A-A



RELEASED

07.07.31

SHOP COPY  
RETURN TO  
ENGINEERING

UNCONTROLLED COPY

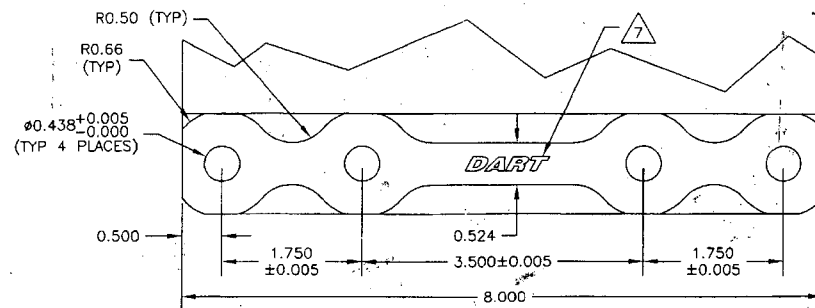
SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 84937 M05

12/05/30

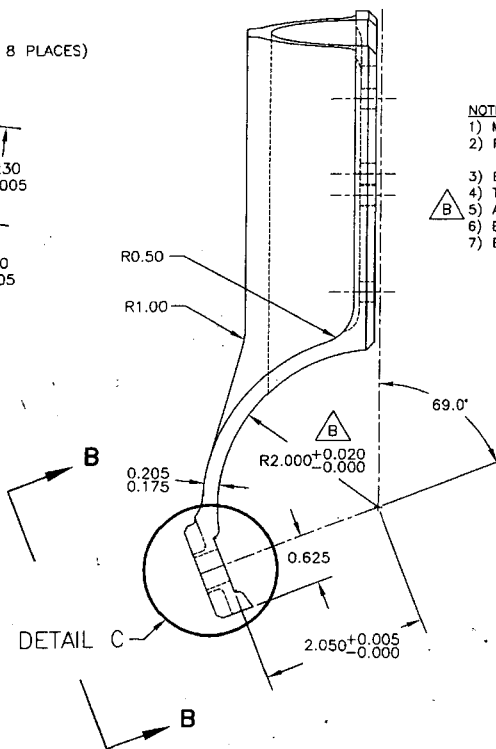


VIEW B-B

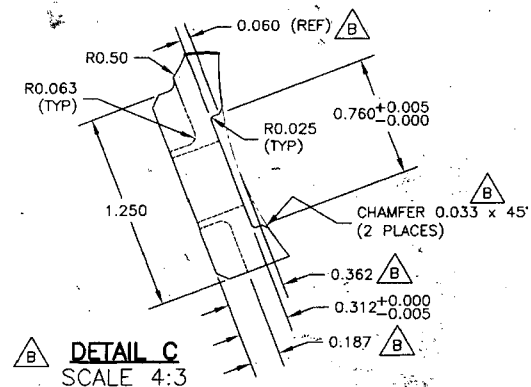
D2917-1 LH SADDLE (SHOWN)  
D2917-2 RH SADDLE (OPPOSITE)

NOTES:

- 1) MATERIAL: ALUMINUM 6061-T6/T651 PER QQ-A-250/11
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005.4.3
- 3) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 7) ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125



DETAIL C



DETAIL C  
SCALE 4:3

B	07.06.26	ADD 0.362, 0.187, 0.060; CHAMFER; ADD DETAIL C; R0.188 WAS R0.30; ADD TOL TO R2.000; ADD NOTES
A	04.05.31	NEW ISSUE
DESIGN	GP	DRAWN BY
CHECKED	PH	APPROVED
DATE	07.06.26	TITLE
		SADDLE

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DART AEROSPACE LTD.

DART

DART AEROSPACE LTD.  
HAWKESBURY, ONTARIO, CANADA

REV. B

SHEET 1 OF 1

SCALE

2:3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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